

# Work Order ID 91673

\*91673\*

October-15-12 8:22:39 AM

Page 1

Item ID: D3189-1

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Stop

\*NS2\*

Item Name: Chafing Shield(send DSI9629 with spares)

Start Date: 15/10/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 29/10/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals: Process Plan: MCS

Date: 12-10-15 Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3189

C

100

0.00

\*100\*

Waterjet

FLOW CNC Waterjet

~~SHEAR~~

Memo

0.00

20

0

Jm 12-11-30

1-Cut as per Dwg

Dwg Rev: C

Prog Rev: C

2-Deburr if necessary

103

QC2- Inspect parts off machine FAI/FAIB

0.00

\*103\*

QC

Quality Control

Memo

0.00

20

0

Jm 12-11-30

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Page 2

Item ID: D3189-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Chafing Shield(send DSI9629 with spares)

Start Date: 15/10/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 29/10/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

105

QC8- Inspect parts - second check

0.00

**\*105\***

QC

Memo

0.00

Quality Control

110

Small Fab

0.00

**\*110\***

Small Fab

Memo

0.00

Small Fab

1- Roll as per Dwg D3189

120

QC5- Inspect part completeness to step on W/O

0.00

**\*120\***

QC

Memo

0.00

Quality Control

# Work Order ID 91673

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**\*91673\***

Page 3

Item ID: D3189-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Chafing Shield(send DSI9629 with spares)

Start Date: 15/10/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 29/10/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: **L653**

0.00

**\*130\***

Packaging

Memo

0.00

Packaging

20

0

0

**AS**

12-12-1

140

QC21- Final Inspection - Work Order Release

0.00

**\*140\***

QC

Memo

0.00

Quality Control

12/12/3 **AS**

12-12-3

# Picklist Print

October-15-12 8:22:46 AM

Page 1

Work Order ID: 91673

\*91673\*

Parent Item: D3189-1

\*D3189-1\*

Parent Item Name: Chafing Shield(send DS19629 with spares)

Start Date: 15/10/2012

Required Date: 29/10/2012

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP B05.08.22No longer made in-houseKJ/JLM

IPP Rev:C 06-03-24 Rolling Now made in House JLM

IPP Rev:D 07-04-16 As per Rev B JLM

IPP Rev:E

11.05.11 now made on waterjet DD verf:JLM

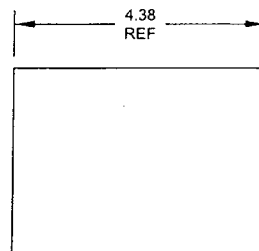
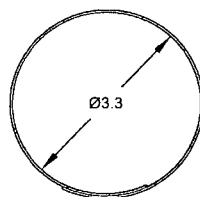
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA		Purchased	No			100	sf	30.1500	0.32	6.736842			
*M304S25GA*										**	6.8		Jm12-11-30
304/316-025" Sheet													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						MAT020	30.15						
						118228	30.15						

304 .025"

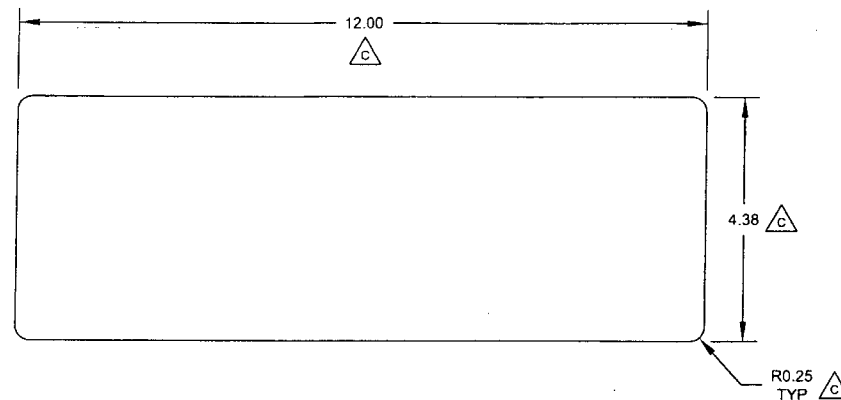
106236

106236





**D3189-1 CHAFING SHIELD**  
(ROLL D3189-1F AS SHOWN)



**D3189-1F FLAT PATTERN**

**RELEASED**  
2012-09-04  
*WMP*

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHIN FACTORY  
WORK ORDER

NO 916-73 MJS  
12-10-15

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.30 lbs

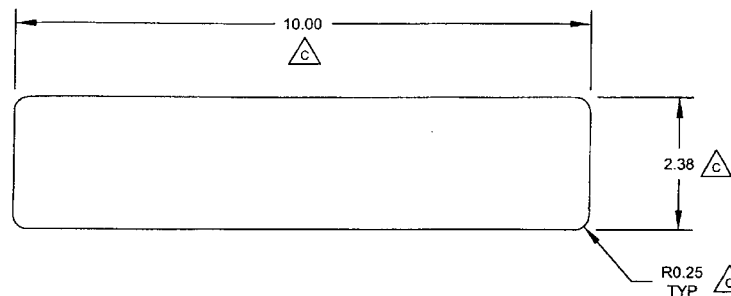
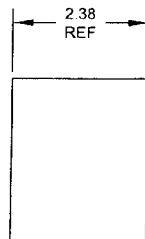
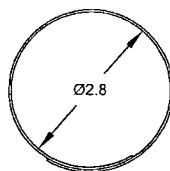
C	-1/3 ENLARGED TO REDUCE CHANCE OF DMG TO CROSSTUBE. ALL FILLETS INCREASED TO R0.25	CP	12.08.14
B	ADD -3	CP	07.01.05
A	NEW ISSUE	CP	03.05.08
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.08.14		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. C  
D3189 SHEET 1 OF 2  
TITLE SCALE  
CHAFING SHIELD NTS

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91673



D3189-3F FLAT PATTERN

D3189-3 CHAFING SHIELD  
(ROLL D3189-3F AS SHOWN)

RELEASED  
2012-09-04

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.13 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3189	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		CHAFING SHIELD	NTS
DATE	12.08.14	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	